

Work Order ID 120035

June-03-14 9:08:05 AM

\*1200.35\*

Page 1

Item ID: D4519-1

B 4 5 1 9 - 1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

B 1 2 0 0 3 5

Stop \*NS2\*

Item Name: Relay Bracket

Start Date: 6/03/14

Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 6/06/14

Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4519

A

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

6061.063

Dwg Rev: A

Prog Rev: A

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

(22) mm 14/06/06

(22) mm 14/06/06

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Item ID: D4519-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Relay Bracket  
 Start Date: 6/03/14 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 6/06/14 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00 DAS 27 9-89 14/6/16				22			
140 <b>*140*</b> Brake NC Brake NC	Bend as per dwg NC BRAKE  Memo	0.00 0.00		DAS 30 9-89		22			14/06/12
150 <b>*150*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00 DAS 27 9-89 14/6/13				22			

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Item ID: D4519-1 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Relay Bracket  
Start Date: 6/03/14 Start Qty: 20.00 \*20\* Cust Item ID:  
Required Date: 6/06/14 Req'd Qty: 20.00 \*20\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00				22	76	14613	
*160*									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00				22			
*170*									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>ST107</u>	0.00				22x			
*180*									
Packaging	Memo	0.00							
Packaging									

DAS  
28  
9-89

JUN 13 2014

Work Order ID 120035

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Item ID: D4519-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Relay Bracket

Start Date: 6/03/14

Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 6/06/14

Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

\*190\*

QC

Memo

0.00

Quality Control

MLJ

14-06-16

14.6.16

# Picklist Print

June-03-14 9:08:05 AM

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Work Order ID: 120035

**\*120035\***

Parent Item: D4519-1

**\*D4519-1\***

Parent Item Name: Relay Bracket

Start Date: 6/03/14

Required Date: 6/06/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.01.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		100	sf	534.2480	0.0378	1			

**\*M6061T6S 063\***

6061-T6 .063 Sheet

**\*\***

mm 14/06/06

Location

Loc Qty

Loc Code

MAT021

534.248

M124446

3.7

M126075

4.5

M127006

9

M127420

117.12

M128054

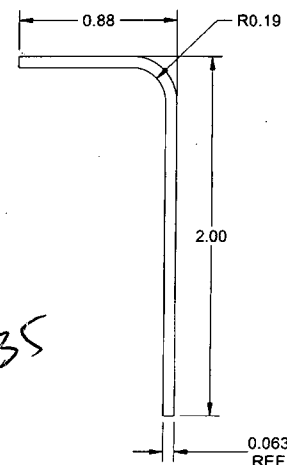
93.928

M128941

306

1.16



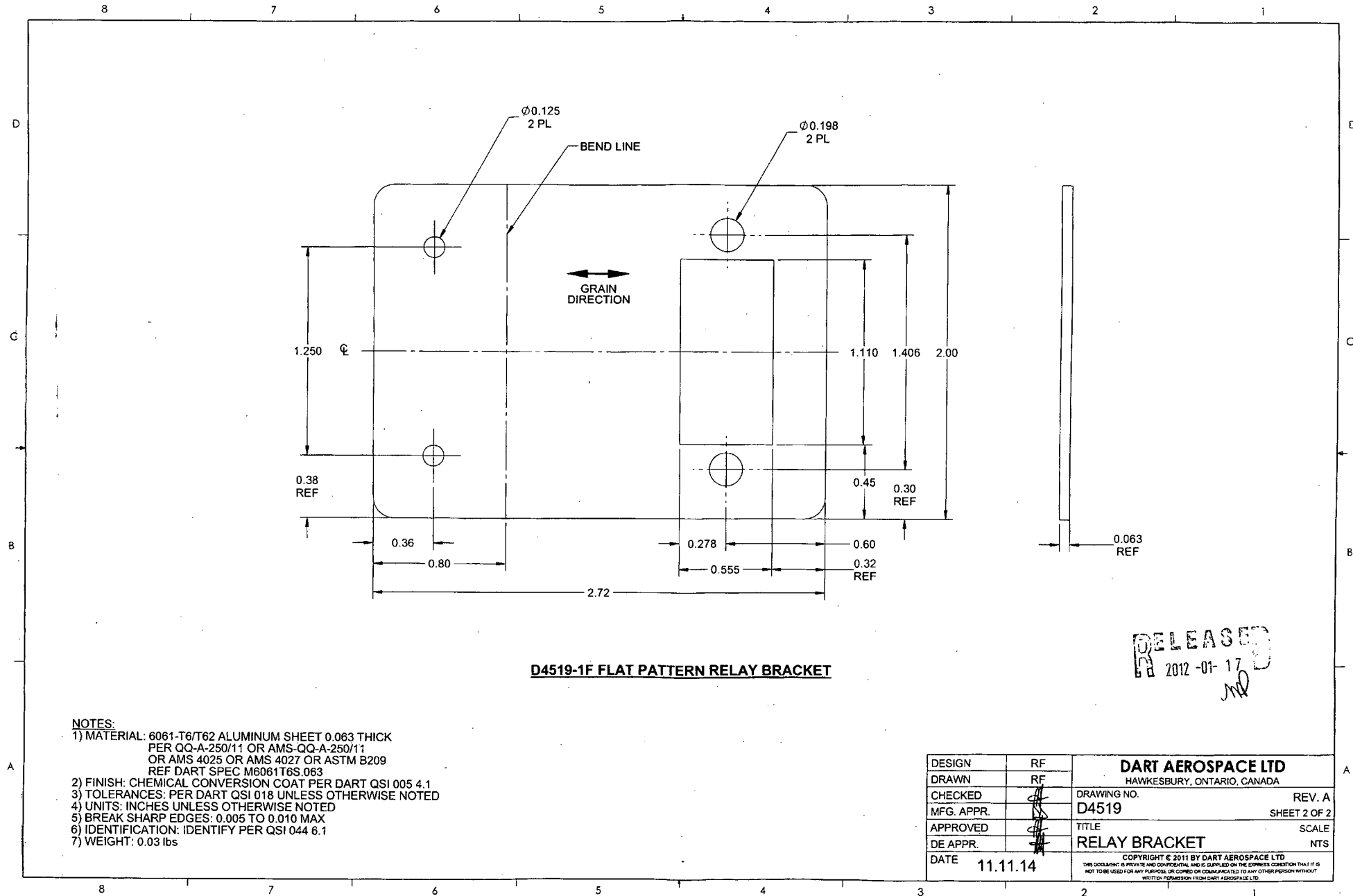


Wb  
(2035

RELEASED  
2012-01-17  
gmd

- 1) MATERIAL: MAKE FROM D4519-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

A	NEW ISSUE		RF	11.11.14
REV.		DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4519</b>  TITLE <b>RELAY BRACKET</b>		
DRAWN	RF			
CHECKED	<del>RF</del>			REV.
MFG. APPR.	<del>RF</del>			SHEET 1 OF 1
APPROVED	<del>RF</del>			SCALE
DE APPR.	<del>RF</del>			NT
DATE	11.11.14	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE BUSINESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD		



**D4519-1F FLAT PATTERN RELAY BRACKET**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4519</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>RELAY BRACKET</b>	NTS
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2012-01-17  
*[Signature]*